

PATENT APPLICATION

OF

PAUL VAN RHEENEN

FOR

A METHOD FOR PREPARING A MULTI-LAYERED POLYMERIC  
COMPOSITE AND A MULTI-LAYERED COMPOSITE PRODUCED THEREBY

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A METHOD FOR PREPARING A MULTI-LAYERED POLYMERIC  
COMPOSITE AND A MULTI-LAYERED COMPOSITE PRODUCED THEREBY

5           This application is a division of Serial Number 09/951,920 filed September 13, 2001, which derives priority from provisional patent application Serial Number 60/232,414 filed September 14, 2000.

10           The present invention relates to: a method of preparing a capstock layer that includes a comb copolymer; a method of preparing a multi-layered polymeric composite, one layer of which is a capstock layer; and a capstock layer and a multi-layered polymeric composite formed, respectively, thereby.

15           The thermoplastic polymer, poly(vinyl chloride) ("PVC") has a combination of properties which make it particularly suitable for use as a structural material. In applications in which impact strength of the structural plastic is important, the PVC can be formulated with impact-modifier resins which improve the impact strength of the resulting composition. Such high impact-strength PVC compositions can be readily extruded or otherwise formed into a variety of articles which have excellent impact strength, toughness and other desired mechanical and chemical properties; for example as siding for buildings, shutters, technical profiles for window and door frames, rain carrying systems (e.g., gutters and downspouts), and fencings.

20           Such PVC compositions however have relatively poor weatherability characteristics, particularly poor color retention in darker grade colors such as browns and blues. The color is imparted to the PVC composition, for instance, by the use of colorants such as pigments or dyes, but exposure to sunlight causes unappealing changes in the colors. Such unappealing changes are more severe for darker than for light colors. Poor weatherability characteristics also cause reduction in impact strength leading to embrittlement and cracking and/or mechanical failure of the articles prepared from such compositions. Thus, there is a need for improving the weathering characteristics of such materials.

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One remedy has been to incorporate stabilizing additives into the PVC composition, for example UV absorbers, thermal stabilizers and titanium dioxide light scatterer. However, the resulting improvements to weatherability are still not sufficient to meet the new, stricter industry-wide standards (Vinyl Siding  
5 Institute, January 1999, adopting ASTM D3679 performance specifications).

Another attempted remedy has been to apply another resinous material over the PVC to provide a surface that can withstand sunlight and other environmental conditions. Such a surfacing material is called a "capstock". The capstock layer generally is much thinner than the thermoplastic substrate layer,  
10 typically being about 5 to about 25% of the total thickness of the composite (i.e. the capstock layer and substrate layer).

A suitable capstock material must possess a certain combination of processing properties and other physical, chemical, and aesthetic properties, including exceptional weathering characteristics such as excellent color retention  
15 and high impact strength. Moreover, the capstock also must not adversely affect those properties which make PVC such a widely used building material. In particular, the capstock compositions that are particularly aesthetically desirable do not have a shiny appearance but rather have a flat, or reduced gloss appearance.

20 Various types of polymer-based compositions have been disclosed for use as capstock, including PVC-based compositions and acrylic resin based compositions. A number of these polymer-based compositions are disclosed in European Patent Application EP-A-473,379. This publication discloses a capstock composition containing a blend of PVC resin and an acrylic copolymer.  
25 We have found, however, that the presence of PVC in capstock compositions such as those disclosed in EP-A- 473,379 results in reduced weatherability and high gloss.

EP-A-1,061,100 discloses a capstock composition that contains a particular combination of "high rubber core" and "medium rubber core" acrylic-based  
30 "core/shell" polymers and is capable of providing the requisite impact strength, high color retention, and reduced gloss without requiring additional PVC or

flatting agents. Unfortunately, this approach is a macroscopic blend approach requiring a processing blend step which is undesirable from an economic point of view. Moreover, because the macroscopic blend approach produces macroscopic domains having sizes on the order of the wavelength of visible light, physical stressing of the capstock layer can be very deleterious to the appearance of the capstock layer, and to the appearance of the composite as a whole. Physical stressing by, for example, bending, creasing, or impact events caused pronounced whitening (so called "stress whitening") at the point of stress.

Thus there is a need for a cost-effective, weatherable, capstock material having a high impact strength, adequate color retention, and resistance to crease or stress whitening.

We have, surprisingly, found that the comb copolymer of the present invention can be melt processed to form a capstock melt layer that can be contacted with a substrate melt layer to form a multi-layered polymeric composite in which the capstock layer displays superior weatherability, impact resistance, other mechanical properties, and stress whitening resistance, and which is capable of protecting the substrate layer from damage associated with weathering and other environmental stress, including impact events.

One aspect of the present invention relates to a capstock composition comprising a comb copolymer:

wherein said comb copolymer comprises a backbone and at least one graft segment; and

wherein:

- (i) said graft segment and said backbone are in a weight ratio from 30:70 to 60:40;
- (ii) said backbone is immiscible with said graft segment at room temperature;
- (iii) said backbone has a glass transition temperature of -65°C to 10°C; and
- (iv) said graft segment has a glass transition temperature of 70 to 180°C.

A second aspect of the present invention relates to a method comprising the steps of:

(A) forming a capstock melt layer by a process comprising the steps of:

- (a) forming a capstock composition;
- 5 (b) feeding said capstock composition into a first extruder comprising a feed section and a metering section;
- (c) metering and melting said capstock composition to form a capstock melt;
- (d) forming said capstock melt into a capstock melt layer; and
- 10 (e) extruding said capstock melt layer;

wherein said capstock composition comprises a comb copolymer comprising a backbone and at least one graft segment; and

wherein:

- 15 (i) said graft segment and said backbone are in a weight ratio from 30:70 to 60:40;
- (ii) said backbone is immiscible with said graft segment at room temperature;
- (iii) said backbone has a glass transition temperature of -65°C to 10°C; and
- 20 (iv) said graft segment has a glass transition temperature of 70°C to 180°C.

A third aspect of the present invention relates to the second aspect further comprising the step: (f) cooling said capstock melt layer to form a solid capstock layer.

25 A fourth aspect of the present invention relates to the second aspect further comprising the following steps:

(B) forming a substrate melt layer by a process comprising the steps of:

- (a) forming a substrate composition;
- (b) feeding said substrate composition into a second extruder
- 30 comprising a feed section and a metering section;

(c) metering and melting said substrate composition to form a substrate melt;

(d) forming said substrate melt into a substrate melt layer;

(e) extruding said substrate melt layer; and

5 wherein said substrate composition comprises a thermoplastic polymer;

(C) causing said capstock melt layer to contact said substrate melt layer to form a multi-layered melt composite; and

10 (D) cooling said multi-layered melt composite to form a multi-layered polymeric composite, comprising a solid capstock layer disposed upon a solid substrate layer.

A fifth aspect of the present invention relates to a multi-layered polymeric composite comprising:

(a) at least one solid substrate layer comprising a thermoplastic resin; and

15 (b) at least one solid capstock layer disposed thereon, wherein said solid capstock layer comprises a comb copolymer:

wherein said comb copolymer comprises a backbone and at least one graft segment; and

wherein:

20 (i) said graft segment and said backbone are in a weight ratio from 30:70 to 60:40;

(ii) said backbone is immiscible with said graft segment at room temperature;

(iii) said backbone has a glass transition temperature of -65°C to 10°C; and

25 (iv) said graft segment has a glass transition temperature of 70 to 180°C.

In yet another aspect, the thermoplastic polymer is a polymer selected from the group consisting of poly(vinyl halide), chlorinated poly(vinyl chloride), ABS terpolymer, polyaromatics including high impact polystyrene (HIPS), polyamides, polyesters, polyolefins including polypropylene, and combinations  
30 thereof.

In a still further aspect, the solid capstock layer of the multi-layered polymeric composite has an impact resistance energy of at least 2 joules.

Used herein, the following terms have these definitions:

The "backbone" of a polymer chain is a collection of polymerized monomer units attached to one another. The attachment is typically achieved by covalent bonding. "Non-terminal" monomer units are directly attached to at least two other monomer units. A "terminal" monomer unit resides at the end of the polymer chain and is directly attached to one other monomer unit. For example, the polymerized monomer units of the backbone may be derived from ethylenically unsaturated monomers. It is required that the composition of the backbone of the comb copolymer of the present invention will be such that the backbone is not miscible with the graft segment of the invention at room temperature. Miscibility between graft segment and backbone may, however, occur at elevated temperature, and in some cases may even be desirable. The solubility parameters of the backbone and the thermoplastic polymer can be estimated and compared to predict miscibility by methods such as that of Van Krevelen, described herein below.

A "linear" polymer (homopolymer or copolymer) is a polymer having a backbone that is not branched. As used herein, the term "linear" is also meant to include polymers wherein a minor amount of branching has occurred. For example, hydrogen abstraction may lead to branching during free radical polymerizations.

A "branched" polymer is a polymer having a first "backbone segment" that has other backbone segments (i.e., "branches") chemically attached to it through a "non-terminal" atom of the first backbone segment. Typically, this first backbone segment and all of the branches have the same, or similar, composition.

A "pendant" group is a group that is attached to the backbone of a polymer. The term pendant may be used to describe a group that is actually part of a polymerized monomer unit. For example, the hydroxyethyl group of a polymerized unit of 2-hydroxyethyl methacrylate may be referred to as a

“pendant hydroxyethyl group”, or as “pendant hydroxy functionality”. It is also common to refer to large groups attached to a polymer backbone as “pendant” when those large groups are compositionally distinct from the backbone polymer. These large groups may themselves be polymer chains. For example, when a  
5 macromonomer becomes incorporated into a polymer chain by reaction with other monomers, the two carbons of its reactive double bond become part of the backbone, while the polymeric chain originally attached to the double bond of the macromonomer becomes a “pendant group” that may, for example, have a molecular weight of 1,000 to 100,000. A “pendant” group may further be  
10 described as “pendant to” the backbone.

A “terminal” group resides at the end of the polymer chain and is chemically attached to a terminal monomer unit. A terminal group may, for example, have a composition distinct from the composition of the backbone of the polymer. A “pendant” group may occur in a “terminal” position. As such, a  
15 “terminal” group is a special case of a “pendant” group.

A “macromonomer” is any low molecular weight water-insoluble polymer or copolymer having at least one terminal ethylenically unsaturated group that is capable of being polymerized in a free radical polymerization process. By “water-insoluble” it is meant having a water solubility of no greater than 150  
20 millimoles/liter at 25°C to 50°C. By “low molecular weight” it is meant that the macromonomer has a degree of polymerization preferably from 10 to 1000, more preferably from 20 to 1,000, and more preferably from 40 to 200. By “degree of polymerization” it is meant the number of polymerized monomer units present in the macromonomer. *See e.g.*, Kawakami in the “Encyclopedia of Polymer Science  
25 and Engineering”, Vol. 9, pp. 195-204, John Wiley & Sons, New York, 1987. Typically, the macromonomer polymer chain contains ethylenically unsaturated monomers, as polymerized units. Preferably, the ethylenically unsaturated monomer is selected to impart low or no water solubility to the macromonomer as previously described herein.



The term "macromonomer aqueous emulsion" is used herein to describe an aqueous emulsion containing macromonomer dispersed therein as water insoluble particles.

5 A "graft segment" is a polymer chain occupying a pendant position along the polymer backbone. A graft segment may include, as polymerized units, one type of monomer or more than one type of monomer. The composition of a graft segment is different from the composition of the backbone polymer to which it is attached, in contrast to a "branch segment" of a branched backbone which has a composition which is the same as, or similar to, other portions the branched  
10 backbone of which it is a part. A "terminal graft segment" resides at an end of a backbone polymer chain and is chemically attached to that backbone polymer chain. A "terminal graft segment" is a special case of a "pendant graft segment".

"Graft copolymers" are macromolecules formed when polymer or copolymer chains are chemically attached as side chains to a polymeric  
15 backbone. Those side chains are the "graft segments" described herein above. Because graft copolymers often chemically combine unlike polymeric segments in one macromolecule, these copolymers have unique properties compared to the corresponding random copolymer analogues. These properties include, for example, mechanical film properties resulting from thermodynamically driven  
20 microphase separation of the copolymer, and decreased melt viscosities resulting in part from the segmental structure of the graft copolymer, and from separation of a soft (i.e., low T<sub>g</sub>) phase. With respect to the latter, reduced melt viscosities can advantageously improve processability of the polymer. *See e.g.*, Hong-Quan Xie and Shi-Biao Zhou, J. Macromol. Sci.-Chem., A27(4), 491-507 (1990);  
25 Sebastian Roos, Axel H.E. Müller, Marita Kaufmann, Werner Siol and Clenens Auschra, "Applications of Anionic Polymerization Research", R.P. Quirk, Ed., ACS Symp. Ser. 696, 208 (1998).

The term "comb copolymer," as used herein, is a type of graft copolymer, wherein the polymeric backbone of the graft copolymer is linear, or essentially  
30 linear, and each side chain (graft segment) of the graft copolymer is formed by a "macromonomer" that is grafted to the polymer backbone. The comb copolymers

may, for example, be prepared by the free radical copolymerization of macromonomer with conventional monomer (e.g., second ethylenically unsaturated monomer).

5 A "comb copolymer segment" is a segment selected from the group consisting of the "backbone" of a comb copolymer and the "graft segment" of a comb copolymer. It is preferred that graft segment of the present invention is miscible with the substrate polymer of the present invention. It is further required that the backbone of the comb copolymer not be miscible with the graft  
10 the comb copolymer of the present invention not be miscible in the substrate polymer. The solubility parameters of a given copolymer segment and the substrate polymer can be estimated and compared to predict miscibility by methods such as that of Van Krevelen described herein below.

15 A "substrate polymer" is a polymer to which the capstock layer is affixed and adhered.

An "aqueous dispersion of a segmental copolymer" is an aqueous medium in which are dispersed a plurality of particles of segmental copolymer. Used herein, an "aqueous dispersion of a segmental copolymer" is an "aqueous copolymer composition".

20 "T<sub>g</sub>" is the "glass transition temperature" of a polymeric phase. The glass transition temperature of a polymer is the temperature at which a polymer transitions from a rigid, glassy state at temperatures below T<sub>g</sub> to a fluid or rubbery state at temperatures above T<sub>g</sub>. The T<sub>g</sub> of a polymer is typically measured by differential scanning calorimetry (DSC) using the mid-point in the  
25 heat flow versus temperature transition as the T<sub>g</sub> value. A typical heating rate for the DSC measurement is 20 Centigrade degrees per minute. The T<sub>g</sub> of various homopolymers may be found, for example, in *Polymer Handbook*, edited by J. Brandrup and E. H. Immergut, Interscience Publishers. The T<sub>g</sub> of a polymer is estimated by using the Fox equation (T.G. Fox, *Bull. Am. Physics*  
30 *Soc.*, Volume 1, Issue No. 3, page 123 (1956)).

“Effective Tg”. When a substance having some degree of solubility in a polymer is imbibed by that polymer, the softening temperature of the polymer decreases. This plasticization of the polymer can be characterized by measuring the “effective Tg” of the polymer, which typically bears an inverse relationship to the amount of solvent or other substance contained in the polymer. The “effective Tg” of a polymer containing a known amount of a substance dissolved within is measured just as described above for “Tg”. Alternatively, the “effective Tg” may be estimated by using the Fox equation (*supra*), assuming a value for Tg (e.g., the freezing point) of the solvent or other substance contained in the polymer.

Molecular Weight. Synthetic polymers are almost always a mixture of chains varying in molecular weight, i.e., there is a “molecular weight distribution”, abbreviated “MWD”. For a homopolymer, members of the distribution differ in the number of monomer units which they contain. This way of describing a distribution of polymer chains also extends to copolymers. Given that there is a distribution of molecular weights, the most complete characterization of the molecular weight of a given sample is the determination of the entire molecular weight distribution. This characterization is obtained by separating the members of the distribution and then quantitating the amount of each that is present. Once this distribution is in hand, there are several summary statistics, or moments, which can be generated from it to characterize the molecular weight of the polymer.

The two most common moments of the distribution are the “weight average molecular weight”, “ $M_w$ ”, and the “number average molecular weight”, “ $M_n$ ”. These are defined as follows:

$$M_w = \Sigma(W_i M_i) / \Sigma W_i = \Sigma(N_i M_i^2) / \Sigma N_i M_i$$

$$M_n = \Sigma W_i / \Sigma (W_i / M_i) = \Sigma (N_i M_i) / \Sigma N_i$$

where:

$M_i$  = molar mass of  $i^{\text{th}}$  component of distribution

$W_i$  = weight of  $i^{\text{th}}$  component of distribution

$N_i$  = number of chains of  $i^{\text{th}}$  component

and the summations are over all the components in the distribution.  $M_w$  and  $M_n$  are typically computed from the MWD as measured by Gel Permeation Chromatography (see the Experimental Section).

5       “Particle size” is the diameter of a particle.

The “average particle size” determined for a collection of particles (e.g., macromonomer particles, or particles of graft copolymer) the “weight average particle size”, “ $d_w$ ”, as measured by Capillary Hydrodynamic Fractionation technique using a Matec CHDF 2000 particle size analyzer equipped with a  
10 HPLC type Ultra-violet detector.

The term “particle size distribution” and the acronym “PSD” are used interchangeably. “Polydispersity” is used in the art as a measure of the breadth of the PSD. Used herein, “polydispersity” is a description of the distribution of particle sizes for a plurality of particles. As such, “polydispersity” and “PSD  
15 polydispersity” are used interchangeably. PSD polydispersity is calculated from the weight average particle size,  $d_w$ , and the number average particle size,  $d_n$ , according to the formulae:

$$\begin{aligned} \text{PSD Polydispersity} &= (d_w)/(d_n), \\ \text{where } d_n &= \frac{\sum n_i d_i}{\sum n_i} \\ d_w &= \frac{\sum n_i d_i^2}{\sum n_i d_i}, \text{ and} \\ &\text{where } n_i \text{ is the number of particles having the particle size } d_i. \end{aligned}$$

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25       Estimation of whether a polymer and another component (i.e., another polymer of a solvent) will be miscible may be made according to the well-known methods delineated in D. W. Van Krevelen, *Properties of Polymers*, 3<sup>rd</sup> Edition, Elsevier, pp. 189-225, 1990. For example, Van Krevelen defines the total solubility parameter ( $\delta_t$ ) for a substance by:

$$\delta_t^2 = \delta_d^2 + \delta_p^2 + \delta_h^2,$$

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where  $\delta_d$ ,  $\delta_p$ , and  $\delta_h$  are the dispersive, polar, and hydrogen bonding components of the solubility parameter, respectively. Values for  $\delta_d$ ,  $\delta_p$ , and  $\delta_h$  have been determined for many solvents, polymers, and polymer segments, and

can be estimated using the group contribution methods of Van Krevelen. For example, to estimate whether a polymer having a given composition will be miscible with a particular solvent, one calculates  $\delta_t^2$  for the polymer and  $\delta_t^2$  for the solvent. Typically, if the difference between the two,  $\Delta\delta_t^2$ , is greater than 25 (i.e.,  $\Delta\delta_t > 5$ ), then the polymer and the solvent will not be miscible.

If, instead, it is desired to determine whether two polymers, differing in composition, will be miscible, the same calculations may be carried out, but the predicted upper limit of  $\Delta\delta_t^2$  for miscibility will decrease as the molecular weight of one or both of polymers under consideration increases. This decrease is thought to parallel the decrease in entropy of mixing which occurs as the molecular weight of the components being mixed increases. For example, two polymers, each having a degree of polymerization of 100, will likely be immiscible even if the value of  $\Delta\delta_t^2$  for their mixture is 9, or even 4 (i.e.,  $\Delta\delta_t = 3$ , or even 2). Still higher molecular weight polymers may be immiscible at even lower values of  $\Delta\delta_t$ . To estimate whether a graft segment of the copolymer of the present invention, having a given composition, will be miscible with a backbone having another composition, one calculates  $\delta_t^2$  for the graft segment and  $\delta_t^2$  for the backbone. Typically, if the difference between the two,  $\Delta\delta_t^2$ , is greater than 9 (i.e.,  $\Delta\delta_t > 3$ ), then the graft segment should be insoluble in the backbone polymer such that a film formed by the graft copolymer would have two distinct types of polymeric phase. Similar calculation can be performed to determine whether a graft segment of a particular composition will be miscible with a thermoplastic polymer of a given composition. Similar calculation can also be performed to determine whether a backbone of a particular composition will be immiscible with a thermoplastic polymer of a given composition.

Used herein, a "solid capstock layer" of the present invention having a composition identical to the composition of Dropping Dart Impact specimens, prepared and tested according to dropping dart impact resistance test ASTM method D-446 with impact head configuration H.25, will be referred to as having a value for impact resistance energy equal to the value for impact resistance energy determined for those Dropping Dart Impact specimens. A solid capstock

layer is herein considered to be impact resistant if the corresponding Dropping Dart Impact specimens having the same composition exhibit dart impact energy (average of ten specimens) of at least 2.0 joules. Preferably, the dart impact energy is 3.0 joules to 9.0 joules, more preferably 4.5 to 9.0 joules, and most preferably 5 to 8 joules.

A preferred method of preparing the graft copolymers of the present invention and their aqueous dispersions is by emulsion polymerization. A preferred process for this preparation includes (a) forming, by polymerization of at least one first ethylenically unsaturated monomer, a macromonomer aqueous emulsion containing one or more water-insoluble particles of macromonomer; (b) forming a monomer composition containing at least one second ethylenically unsaturated monomer; and (c) combining at least a portion of the macromonomer aqueous emulsion and at least a portion of the monomer composition to form a "polymerization reaction mixture". The macromonomer and second ethylenically unsaturated monomer are polymerized in the presence of an initiator to form graft copolymer particles. The graft copolymers prepared by this preferred process are comb copolymers.

The macromonomer, present in the macromonomer aqueous emulsion as water insoluble particles, is any low molecular weight water-insoluble polymer or copolymer having at least one terminal ethylenically unsaturated group that is capable of being polymerized in a free radical polymerization process. By "water-insoluble" it is meant having a water solubility of no greater than 150 millimoles/liter at 25°C to 50°C. By "low molecular weight" it is meant that the macromonomer, typically, has a degree of polymerization of 10 to 2,000, preferably from 10 to 1,000, more preferably from 20 to 1,000, and most preferably from 40 to 200. By "degree of polymerization" it is meant the number of polymerized monomer units present in the macromonomer.

The macromonomer contains, as polymerized units, at least one first ethylenically unsaturated monomer. Preferably, the first ethylenically unsaturated monomer is selected to impart low or no water solubility to the macromonomer as previously described herein.

It is preferred, though not required, that the composition of the macromonomer be chosen such that the graft segments of the comb copolymer formed therefrom will be miscible in the substrate polymer of the invention. The solubility parameters of the macromonomer (and graft segment prepared therefrom) and the substrate polymer can be estimated and compared to predict miscibility by methods such as that of Van Krevelen, described herein above.

The composition of the macromonomer should be chosen so that the T<sub>g</sub> of the graft segment of the comb copolymer formed therefrom will be preferably from 60 °C to 180 °C, more preferably from 70 °C to 130 °C, and most preferably from 80 °C to 120 °C.

Suitable first ethylenically unsaturated monomers for use in preparing macromonomer include for example methacrylate esters, such as C<sub>1</sub> to C<sub>18</sub> normal or branched alkyl esters of methacrylic acid, including methyl methacrylate, ethyl methacrylate, n-butyl methacrylate, lauryl methacrylate, stearyl methacrylate; acrylate esters, such as C<sub>1</sub> to C<sub>18</sub> normal or branched alkyl esters of acrylic acid, including methyl acrylate, ethyl acrylate, n-butyl acrylate and 2-ethylhexyl acrylate; styrene; substituted styrenes, such as methyl styrene, a-methyl styrene or t-butyl styrene; olefinically unsaturated nitriles, such as acrylonitrile or methacrylonitrile; olefinically unsaturated halides, such as vinyl chloride, vinylidene chloride or vinyl fluoride; vinyl esters of organic acids, such as vinyl acetate; N-vinyl compounds such as N-vinyl pyrrolidone; acrylamide; methacrylamide; substituted acrylamides; substituted methacrylamides; hydroxyalkylmethacrylates such as hydroxyethylmethacrylate; hydroxyalkylacrylates; basic substituted (meth)acrylates and (meth)acrylamides, such as amine-substituted methacrylates including dimethylaminoethyl methacrylate, tertiary-butylaminoethyl methacrylate and dimethylaminopropyl methacrylamide and the likes; dienes such as 1,3-butadiene and isoprene; vinyl ethers; or combinations thereof. The term "(meth)" as used herein means that the "meth" is optionally present. For example, "(meth)acrylate" means methacrylate or acrylate.

The first ethylenically unsaturated monomer can also be a functional monomer including for example monomers containing hydroxy, amido, aldehyde, ureido, polyether, glycidylalkyl, keto functional groups or combinations thereof. These functional monomers are generally present in the macromonomer at a level of from 0.1 weight percent to 15 weight percent and more preferably from 0.5 weight percent to 10 weight percent, and most preferably from 1.0 to 3 weight percent, based on the total weight of the graft copolymer. Used herein, all ranges are inclusive and combinable. Examples of functional monomers include ketofunctional monomers such as the acetoacetoxy esters of hydroxyalkyl acrylates and methacrylates (e.g., acetoacetoxyethyl methacrylate) and keto-containing amides (e.g., diacetone acrylamide); allyl alkyl methacrylates or acrylates; glycidylalkyl methacrylates or acrylates; or combinations thereof. Such functional monomers can provide crosslinking if desired.

The macromonomer typically also contains as polymerized units less than 10 weight percent, preferably less than 5 weight percent, more preferably less than 2 weight percent and most preferably less than 1 weight percent "acid containing monomer", based on the total weight of the macromonomer. In a most preferred embodiment, the macromonomer contains no acid containing monomer. Used herein, "acid containing monomer" and "acid functional monomer" are used interchangeably. By "acid containing monomer" it is meant any ethylenically unsaturated monomer that contains one or more acid functional groups or functional groups that are capable of forming an acid (e.g., an anhydride such as methacrylic anhydride or tertiary butyl methacrylate). Examples of acid containing monomers include, for example, carboxylic acid bearing ethylenically unsaturated monomers such as acrylic acid, methacrylic acid, itaconic acid, maleic acid and fumaric acid; acryloxypropionic acid and (meth)acryloxypropionic acid; sulphonic acid-bearing monomers, such as styrene sulfonic acid, sodium vinyl sulfonate, sulfoethyl acrylate, sulfoethyl methacrylate, ethylmethacrylate-2-sulphonic acid, or 2-acrylamido-2-methylpropane sulphonic acid; phosphoethylmethacrylate; the corresponding salts of the acid containing monomer; or combinations thereof.



The macromonomer may also contain as polymerized units, mercapto-olefins. Used herein, "mercapto-olefin" and "mercaptan-olefin" are used interchangeably. These mercapto-olefin compounds are those as disclosed in US-A-5,247,000 to Amick. Further, the methods of US-A-5,247,000 may be utilized to prepare comb copolymers of the present invention.

In a preferred embodiment of the present invention, the macromonomer is composed of 20 weight percent to 100 weight percent, more preferably from 50 to 100 weight percent, and most preferably from 70 to 100 weight percent, based on total weight of macromonomer, of at least one  $\alpha$ -methyl vinyl monomer, a non  $\alpha$ -methyl vinyl monomer terminated with an  $\alpha$ -methyl vinyl monomer, or combinations thereof. In a most preferred embodiment of the present invention the macromonomer contains as polymerized units from 90 to 100 weight percent  $\alpha$ -methyl vinyl monomers, non  $\alpha$ -methyl vinyl monomers terminated with  $\alpha$ -methyl vinyl monomers, or combinations thereof, based on the total weight of the macromonomer. The phrase "non  $\alpha$ -methyl vinyl monomer terminated with an  $\alpha$ -methyl vinyl monomer" means that, when a vinyl monomer bearing no  $\alpha$ -methyl group is present, as polymerized units, in the macromonomer, the macromonomer must be terminated by a unit derived from an  $\alpha$ -methyl vinyl monomer. For example, while styrene might be present, as polymerized units, in a macromonomer chain, that macromonomer chain would be terminated by  $\alpha$ -methyl styrene, or some other  $\alpha$ -methyl vinyl monomer. Suitable  $\alpha$ -methyl vinyl monomers include, for example, methacrylate esters, such as C<sub>1</sub> to C<sub>18</sub> normal or branched alkyl esters of methacrylic acid, including methyl methacrylate, ethyl methacrylate, butyl methacrylate, 2-ethylhexyl methacrylate, isobornyl methacrylate, lauryl methacrylate, or stearyl methacrylate; hydroxyalkyl methacrylates such as hydroxyethyl methacrylate; glycidylmethacrylate; phenyl methacrylate; methacrylamide; methacrylonitrile; or combinations thereof.

One skilled in the art will recognize that there are many ways to prepare the macromonomer useful in the present invention. For example, the macromonomer may be prepared by a high temperature (e.g., at least 150°C) continuous process such as disclosed in US-A-5,710,227 or EP-A-1,010,706,

published June 21, 2000. In a preferred continuous process, a reaction mixture of first ethylenically unsaturated monomers is passed through a heated zone having a temperature of at least 150°C, and more preferably at least 275°C. The heated zone may also be maintained at a pressure above atmospheric pressure (e.g., greater than 3,000 kPa = greater than 30 bar). The reaction mixture of monomers may also optionally contain a solvent such as water, acetone, methanol, isopropanol, propionic acid, acetic acid, dimethylformamide, dimethylsulfoxide, methylethylketone, or combinations thereof.

The macromonomer useful in the present invention may also be prepared by polymerizing first ethylenically unsaturated monomers in the presence of a free radical initiator and a catalytic metal chelate chain transfer agent (e.g., a transition metal chelate). Such a polymerization may be carried out by a solution, bulk, suspension, or emulsion polymerization process. Suitable methods for preparing the macromonomer using a catalytic metal chelate chain transfer agent are disclosed in for example U.S. Patent Nos. 4,526,945, 4,680,354, 4,886,861, 5,028,677, 5,362,826, 5,721,330, and 5,756,605; European publications EP-A-0199,436, and EP-A-0196783; and PCT publications WO 87/03605, WO 96/15158, and WO 97/34934.

Preferably, the macromonomer useful in the present invention is prepared by an aqueous emulsion free radical polymerization process using a transition metal chelate complex. Preferably, the transition metal chelate complex is a cobalt (II) or (III) chelate complex such as, for example, dioxime complexes of cobalt (II), cobalt (II) porphyrin complexes, or cobalt (II) chelates of vicinal iminohydroxyimino compounds, dihydroxyimino compounds, diazadihydroxyiminodialkyldecadienes, or diazadihydroxyiminodialkylundecadienes, or combinations thereof. These complexes may optionally include bridging groups such as BF<sub>2</sub>, and may also be optionally coordinated with ligands such as water, alcohols, ketones, and nitrogen bases such as pyridine. Additional suitable transition metal complexes are disclosed in for example U.S. Patent Nos. 4,694,054; 5,770,665; 5,962,609; and 5,602,220. A preferred cobalt chelate complex useful in the present invention is Co II (2,3-dioxyiminobutane-BF<sub>2</sub>)<sub>2</sub>, the

Co III analogue of the aforementioned compound, or combinations thereof. The spatial arrangements of such complexes are disclosed in for example EP-A-199436 and U.S. Patent No. 5,756,605.

5 In preparing macromonomer by an aqueous emulsion polymerization process using a transition metal chelate chain transfer agent, at least one first ethylenically unsaturated monomer is polymerized in the presence of a free radical initiator and the transition metal chelate according to conventional aqueous emulsion polymerization techniques. Preferably, the first ethylenically unsaturated monomer is an  $\alpha$ -methyl vinyl monomer as previously described  
10 herein.

The polymerization to form the macromonomer is preferably conducted at a temperature of from 20°C to 150°C, and more preferably from 40°C to 95°C. The solids level at the completion of the polymerization is typically from 5 weight percent to 70 weight percent, and more preferably from 30 weight percent  
15 to 60 weight percent, based on the total weight of the aqueous emulsion.

The concentration of initiator and transition metal chelate chain transfer agent used during the polymerization process is preferably chosen to obtain the desired degree of polymerization of the macromonomer. Preferably, the concentration of initiator is from 0.2 weight percent to 3 weight percent, and  
20 more preferably from 0.5 weight percent to 1.5 weight percent, based on the total weight of monomer. Preferably, the concentration of transition metal chelate chain transfer agent is from 5 ppm to 200 ppm, and more preferably from 10 ppm to 100 ppm, based on the total monomers used to form the macromonomer.

The first ethylenically unsaturated monomer, initiator, and transition  
25 metal chelate chain transfer agent may be added in any manner known to those skilled in the art to carry out the polymerization. For example, the monomer, initiator and transition metal chelate may all be present in the aqueous emulsion at the start of the polymerization process (i.e., a batch process). Alternatively, one or more of the components may be gradually fed to an aqueous  
30 solution (i.e., a continuous or semi-batch process). For example, it may be desired to gradually feed the entire or a portion of the initiator, monomer, and/or

transition metal chelate to a solution containing water and surfactant. In a preferred embodiment, at least a portion of the monomer and transition metal chelate are gradually fed during the polymerization, with the remainder of the monomer and transition metal chelate being present in the aqueous emulsion at the start of the polymerization. In this embodiment, the monomer may be fed as is, or suspended or emulsified in an aqueous solution prior to being fed.

Any suitable free radical initiator may be used to prepare the macromonomer. The initiator is preferably selected based on such parameters as its solubility in one or more of the other components (e.g., monomers, water); half life at the desired polymerization temperature (preferably a half life within the range of from about 30 minutes to about 10 hours), and stability in the presence of the transition metal chelate. Suitable initiators include for example azo compounds such as 2,2'-azobis (isobutyronitrile), 4,4'-azobis(4-cyanovaleric acid), 2,2'-azobis [2-methyl-N-(1,1-bis(hydroxymethyl)-2-(hydroxyethyl)]-propionamide, and 2,2'-azobis [2-methyl-N-(2-hydroxyethyl)]-propionamide; peroxides such as t-butyl hydroperoxide, benzoyl peroxide; sodium, potassium, or ammonium persulphate or combinations thereof. Redox initiator systems may also be used, such as for example persulphate or peroxide in combination with a reducing agent such as sodium metabisulphite, sodium bisulfite, sodium formaldehyde sulfoxylate, isoascorbic acid, or combinations thereof. Metal promoters, such as iron, may also optionally be used in such redox initiator systems. Also, buffers, such as sodium bicarbonate may be used as part of the initiator system.

An emulsifier is also preferably present during the aqueous emulsion polymerization process to prepare the macromonomer. Any emulsifier may be used that is effective in emulsifying the monomers such as for example anionic, cationic, or nonionic emulsifiers. In a preferred embodiment, the emulsifier is anionic such as for example sodium, potassium, or ammonium salts of dialkylsulphosuccinates; sodium, potassium, or ammonium salts of sulphated oils; sodium, potassium, or ammonium salts of alkyl sulphonic acids, such as sodium dodecyl benzene sulfonate; sodium, potassium, or ammonium salts of alkyl sulphates, such as sodium lauryl sulfate; ethoxylated alkyl ether sulfates;

alkali metal salts of sulphonic acids; C12 to C24 fatty alcohols, ethoxylated fatty acids or fatty amides; sodium, potassium, or ammonium salts of fatty acids, such as Na stearate and Na oleate; or combinations thereof. The amount of emulsifier in the aqueous emulsion is preferably from 0.05 weight percent to 10 weight percent, and more preferably from 0.3 weight percent to 3 weight percent, based on the total weight of the monomers.

The macromonomer thus prepared is emulsion polymerized with at least one second ethylenically unsaturated monomer to form a copolymer composition containing graft copolymer particles. The polymerization is carried out by providing the macromonomer as water insoluble particles in a macromonomer aqueous emulsion and the second ethylenically unsaturated monomer in a monomer composition. At least a portion of the macromonomer aqueous emulsion is combined with at least a portion of the monomer composition to form a polymerization reaction mixture that is polymerized in the presence of an initiator.

Although in no way intending to be bound by theory, it is believed that by providing the macromonomer in the form of water insoluble macromonomer particles in an aqueous emulsion, and the second ethylenically unsaturated monomer in a separate monomer composition, upon combination, the second ethylenically unsaturated monomer diffuses through the aqueous phase and then into the macromonomer particles where the polymerization occurs. Preferably, the diffusion of the second ethylenically unsaturated monomer into the macromonomer particles is evidenced by swelling of the macromonomer particles. It is an essential feature of the invention that, prior to being combined with the monomer composition, the macromonomers are present in plural discrete particles dispersed in the aqueous phase. Preferably, these plural macromonomer particles have previously been formed by aqueous emulsion polymerization, and the resultant macromonomer aqueous emulsion is combined with the monomer composition and subsequently polymerized without being isolated. Addition of the monomer composition to the macromonomer aqueous emulsion results initially in the presence of plural monomer droplets in the

aqueous emulsion as separate entities distributed among, but not in direct contact with, the plural macromonomer particles. That is, the monomer droplets are separated from the macromonomer particles, and from each other, by an aqueous phase. Individual monomer molecules must then exit the monomer droplet, dissolve in the aqueous phase, diffuse through that aqueous phase to a macromonomer particle, and enter that macromonomer particle where polymerization to form the graft copolymer (i.e., comb copolymer) occurs. Because the water insoluble macromonomers are unable to diffuse through the aqueous phase, it is essential that the monomer droplets not include water insoluble macromonomer if gel formation is to be avoided and if the number of particles initially established by the macromonomer particles is to be maintained during polymerization of monomers with macromonomers.

The macromonomer aqueous emulsion useful in the present invention may be formed in any manner known to those skilled in the art. For example, the macromonomer, produced by any known method, may be isolated as a solid (e.g., spray dried) and emulsified in water. Also, for example, the macromonomer, if prepared via an emulsion or aqueous based polymerization process, may be used as is, or diluted with water or concentrated to a desired solids level.

In a preferred embodiment of the present invention, the macromonomer aqueous emulsion is formed from the emulsion polymerization of at least one first ethylenically unsaturated monomer in the presence of a transition metal chelate chain transfer agent as described previously herein. This embodiment is preferred for numerous reasons. For example, the macromonomer polymerization can be readily controlled to produce a desired particle size distribution (preferably narrow, e.g., polydispersity less than 2). Also, for example, additional processing steps, such as isolating the macromonomer as a solid, can be avoided, leading to better process economics. In addition, the macromonomer, macromonomer aqueous emulsion, and the graft copolymer can be prepared by consecutive steps in a single reactor which is desirable in a commercial manufacturing facility because process parameters, such as manufacturing cost and particle size distribution, may be optimized.

The "macromonomer aqueous emulsion" useful in the present invention contains from 20 weight percent to 60 weight percent, and more preferably from 30 weight percent to 50 weight percent of at least one water insoluble macromonomer, based on the total weight of macromonomer aqueous emulsion.

5 The macromonomer aqueous emulsion may also contain mixtures of macromonomer. Preferably, the macromonomer aqueous emulsion contains less than 5 weight percent and more preferably less than 1 weight percent of ethylenically unsaturated monomer, based on the total weight of macromonomer aqueous emulsion.

10 The water insoluble macromonomer particles have a particle size chosen such that, upon addition of monomers, particles of graft copolymer (i.e., comb copolymer) having a desired particle size will be formed. For example, the final graft copolymer particle size is directly proportional to the initial particle size of the macromonomer and the concentration of second ethylenically unsaturated  
15 monomer in the polymerization reaction mixture, assuming all the particles participate equally in the polymerization. Typically, the macromonomer particles, typically, have a weight average particle size of from 50 nm to 1,000 nm, preferably from 50 nm to 500 nm, and more preferably from 80 nm to 200 nm as measured by Capillary Hydrodynamic Fractionation technique using a  
20 Matec CHDF 2000 particle size analyzer equipped with a HPLC type Ultra-violet detector.

The macromonomer aqueous emulsion may also include one or more emulsifying agents. The type and amount of emulsifying agent is preferably selected in a manner to produce the desired particle size. Suitable emulsifying  
25 agents include those previously disclosed for use in preparing the macromonomer by an emulsion polymerization process. Preferred emulsifying agents are anionic surfactants such as, for example, sodium lauryl sulfate, sodium dodecylbenzene sulfonate, sulfated and ethoxylated derivatives of nonylphenols and fatty alcohols. The total level of emulsifying agent, based on the total weight of  
30 macromonomer is preferably from 0.2 weight percent to 5 weight percent and more preferably from 0.5 weight percent to 2 weight percent.

The "monomer composition" useful in the present invention contains at least one kind of second ethylenically unsaturated monomer. The monomer composition may contain all (i.e., 100%) monomer, or contain monomer dissolved or dispersed in an organic solvent and/or water. Preferably, the level of monomer in the monomer composition is from 50 weight percent to 100 weight percent, more preferably from 60 to 90 weight percent, and most preferably from 70 to 80 weight percent, based on the total weight of the monomer composition. Examples of organic solvents that may be present in the monomer composition include C<sub>6</sub> to C<sub>14</sub> alkanes. The organic solvent in the monomer composition will be no more than 30 weight percent, and more preferably no more than 5 weight percent, based on the total weight of the monomer composition.

In addition to water and/or organic solvent, the monomer composition may also optionally contain monomers containing functional groups, such as, for example, monomers containing hydroxy, amido, aldehyde, ureido, polyether, glycidylalkyl, keto groups or combinations thereof. These other monomers are generally present in the monomer composition at a level of from 0.5 weight percent to 15 weight percent, and more preferably from 1 weight percent to 3 weight percent based on the total weight of the graft copolymer. Examples of functional monomers include ketofunctional monomers such as the acetoacetoxy esters of hydroxyalkyl acrylates and methacrylates (e.g., acetoacetoxyethyl methacrylate) and keto-containing amides (e.g., diacetone acrylamide); allyl alkyl methacrylates or acrylates; glycidylalkyl methacrylates or acrylates; or combinations thereof. Such functional monomer can provide crosslinking if desired.

In a preferred embodiment, the monomers in the monomer composition are pre-emulsified in water to form a "monomer aqueous emulsion". Preferably, the monomer aqueous emulsion contains monomer droplets having a droplet size from 1 micron to 100 microns, and more preferably from 5 micron to 50 microns. Any suitable emulsifying agent may be used, for example those previously described, to emulsify the monomer to the desired monomer droplet size. Preferably, the level of emulsifying agent, if present, will be from 0.2 weight



percent to 2 weight percent based on the total weight of monomer in the monomer composition.

The second ethylenically unsaturated monomer of the monomer composition is preferably selected to provide the desired properties in the resulting comb copolymer composition. Preferably, the second ethylenically unsaturated monomers are chosen so that, when they have been polymerized to form the backbone of the comb copolymer, that backbone will preferably have a Tg of -65 °C to 10 °C, more preferably -45 °C to 10 °C, and most preferably -40 °C to 0°C, estimated as described herein above. Suitable ethylenically unsaturated monomers include for example methacrylate esters, such as C<sub>1</sub> to C<sub>18</sub> normal or branched alkyl esters of methacrylic acid, including methyl methacrylate, ethyl methacrylate, n-butyl methacrylate, 2-ethylhexyl methacrylate, lauryl methacrylate, stearyl methacrylate, isobornyl methacrylate; acrylate esters, such as C<sub>1</sub> to C<sub>18</sub> normal or branched alkyl esters of acrylic acid, including methyl acrylate, ethyl acrylate, n-butyl acrylate and 2-ethylhexyl acrylate; styrene; substituted styrenes, such as methyl styrene, a-methyl styrene or t-butyl styrene; olefinically unsaturated nitriles, such as acrylonitrile or methacrylonitrile; olefinically unsaturated halides, such as vinyl chloride, vinylidene chloride or vinyl fluoride; vinyl esters of organic acids, such as vinyl acetate; N-vinyl compounds such as N-vinyl pyrrolidone; acrylamide; methacrylamide; substituted acrylamides; substituted methacrylamides; hydroxyalkylmethacrylates such as hydroxyethylmethacrylate; hydroxyalkylacrylates; dienes such as 1,3-butadiene and isoprene; vinyl ethers; or combinations thereof. The ethylenically unsaturated monomer can also be an acid containing monomer or a functional monomer, such as those previously described herein. Preferably, the ethylenically unsaturated monomer of the monomer composition does not contain amino groups.

In a preferred embodiment, the monomer composition includes one or more ethylenically unsaturated monomers selected from C<sub>1</sub> to C<sub>18</sub> normal or branched alkyl esters of acrylic acid, including methyl acrylate, ethyl acrylate, n-butyl acrylate and 2-ethylhexyl acrylate; styrene; substituted styrenes, such as

methylethyl styrene,  $\alpha$ -methyl styrene or t-butyl styrene; butadiene or combinations thereof.

As previously mentioned, the macromonomer aqueous emulsion and monomer composition are combined to form a "polymerization reaction mixture", and polymerized in the presence of a free radical initiator to form an "aqueous copolymer composition", also referred to herein as an "aqueous dispersion of a segmental copolymer". The term "polymerization reaction mixture," as used herein, refers to the resulting mixture formed when at least a portion of the macromonomer aqueous emulsion and at least a portion of the monomer composition are combined. The polymerization reaction mixture may also contain initiator or any other additive used during the polymerization. Thus, the polymerization reaction mixture is a mixture that changes in composition as the macromonomer and monomer (i.e., second ethylenically unsaturated monomer) of the monomer composition are reacted to form comb copolymer.

The macromonomer aqueous emulsion and monomer composition may be combined in various ways to carry out the polymerization. For example, the macromonomer aqueous emulsion and the monomer composition may be combined prior to the start of the polymerization reaction to form the polymerization reaction mixture. Alternatively, the monomer composition could be gradually fed into the macromonomer aqueous emulsion, or the macromonomer aqueous emulsion could be gradually fed into the monomer composition. It is also possible that only a portion of the macromonomer aqueous emulsion and/or monomer composition be combined prior to the start of the polymerization with the remaining monomer composition and/or macromonomer aqueous emulsion being fed during the polymerization.

The initiator can also be added in various ways. For example, the initiator may be added in "one shot" to the macromonomer aqueous emulsion, the monomer composition, or a mixture of the macromonomer aqueous emulsion and the monomer composition at the start of the polymerization. Alternatively, all or a portion of the initiator can be co-fed as a separate feed stream, as part of

the macromonomer aqueous emulsion, as part of the monomer composition, or any combination of these methods.

The preferred method of combining the macromonomer aqueous emulsion, the monomer composition, and initiator will depend on such factors as the  
5 desired graft copolymer composition. For example, the distribution of the macromonomer as a graft along the backbone can be affected by the concentrations of both the macromonomer and the second ethylenically unsaturated monomers at the time of the polymerization. In this regard, a batch process will afford high concentration of both the macromonomer and the second  
10 ethylenically unsaturated monomers at the onset of the polymerization whereas a semi-continuous process will keep the second ethylenically unsaturated monomer concentration low during the polymerization. Thus, through the method by which the macromonomer aqueous emulsion and monomer composition are combined, it is possible to control, for example: the number of  
15 graft segments, derived from macromonomer, per polymer chain; the distribution of graft segments in each chain, and the length of the polymer backbone.

Initiators useful in polymerizing the macromonomer and second ethylenically unsaturated monomer include any suitable initiator for emulsion polymerizations known to those skilled in the art. The selection of the initiator  
20 will depend on such factors as the initiator's solubility in one or more of the reaction components (e.g. monomer, macromonomer, water); and half life at the desired polymerization temperature (preferably a half life within the range of from about 30 minutes to about 10 hours). Suitable initiators include those previously described herein in connection with forming the macromonomer, such  
25 as azo compounds such as 4,4'-azobis(4'-cyanovaleric acid), peroxides such as t-butyl hydroperoxide; sodium, potassium, or ammonium persulfate; redox initiator systems such as, for example, persulphate or peroxide in combination with a reducing agent such as sodium metabisulfite, sodium bisulfite, sodium formaldehyde sulfoxylate, isoascorbic acid; or combinations thereof. Metal  
30 promoters, such as iron; and buffers, such as sodium bicarbonate, may also be used in combination with the initiator. Additionally, Controlled Free Radical

Polymerization (CFRP) methods such as Atom Transfer Radical Polymerization; or Nitroxide Mediated Radical Polymerization may be used. Preferred initiators include azo compounds such as 4,4'-azobis(4-cyanovaleric acid).

The amount of initiator used will depend on such factors as the copolymer desired and the initiator selected. Preferably, from 0.1 weight percent to 1 weight percent initiator is used, based on the total weight of monomer and macromonomer.

The polymerization temperature will depend on the type of initiator chosen and desired polymerization rates. Preferably, however, the macromonomer and second ethylenically unsaturated monomer are polymerized at a temperature of from 0°C to 150°C, and more preferably from 20°C to 95°C.

The amount of macromonomer aqueous emulsion and monomer composition added to form the polymerization reaction mixture will depend on such factors as the concentrations of macromonomer and second ethylenically unsaturated monomer in the macromonomer aqueous emulsion and monomer composition, respectively, and the desired comb copolymer composition. Preferably, the macromonomer aqueous emulsion and monomer composition are added in amounts to provide a comb copolymer containing as polymerized units from 50 weight percent to 70 weight percent, and more preferably from 55 weight percent to 65 weight percent second ethylenically unsaturated monomer.

One skilled in the art will recognize that other components used in conventional emulsion polymerizations may optionally be used in the method of the present invention. For example, to reduce the molecular weight of the resulting graft copolymer, the polymerization may optionally be conducted in the presence of one or more chain transfer agents, such as n-dodecyl mercaptan, thiophenol; halogen compounds such as bromotrichloromethane; or combinations thereof. Also, additional initiator and/or catalyst may be added to the polymerization reaction mixture at the completion of the polymerization reaction to reduce any residual monomer, (e.g., chasing agents). Suitable initiators or catalysts include those initiators previously described herein. In addition, the chain transfer capacity of a macromonomer through addition-fragmentation can

be utilized in part to reduce molecular weight through appropriate design of monomer compositions and polymerization conditions. *See e.g.*, E. Rizzardo, *et. al.*, Prog. Pacific Polym. Sci., 1991, 1, 77-88; G. Moad, *et. al.*, WO 96/15157.

5 Preferably, the process of the present invention does not require neutralization of the monomer, or resulting aqueous graft copolymer composition. These components preferably remain in unneutralized form (e.g., no neutralization with a base if acid functional groups are present).

10 The resulting aqueous graft copolymer composition formed by polymerization of the macromonomer and the ethylenically unsaturated monomer in the monomer composition preferably has a solids level of from 30 weight percent to 70 weight percent and more preferably from 40 weight percent to 60 weight percent. The aqueous graft copolymer composition typically contains graft copolymer particles that are water insoluble and have a particle size of from, 60 nm to 1,000 nm, preferably from 60 nm to 500 nm, and more  
15 preferably from 80 nm to 350 nm.

The graft copolymer formed preferably has a backbone containing, as polymerized units, the second ethylenically unsaturated monomer from the monomer composition, and one or more macromonomer units, as polymerized units, wherein a terminal ethylenically unsaturated group of the macromonomer  
20 is incorporated into the backbone and the remainder of the macromonomer becomes a graft segment pendant to the backbone (i.e., a side chain) upon polymerization. Preferably, each side chain is a graft segment derived from the grafting of one macromonomer to the backbone. The degree of polymerization of the graft segments derived from the macromonomer is preferably from 10 to  
25 1,000, more preferably from 20 to 1,000, and most preferably from 40 to 200, where the degree of polymerization is expressed as the number of polymerized units of ethylenically unsaturated monomer used to form the macromonomer. The weight average molecular weight of the graft copolymer (i.e., of the comb copolymer) is preferably in the range of from 80,000 to 2,000,000, and more  
30 preferably from 100,000 to 1,000,000. The number average molecular weight of a comb copolymer is typically less than the corresponding weight average

molecular weight. The number average molecular weights of the comb copolymers of the present invention are at least 25,000, and typically range from 25,000 to 600,000. Weight average molecular weights as used herein can be determined by size exclusion chromatography.

5       The comb copolymer particles of the aqueous graft copolymer composition can be isolated, for example, by spray drying or coagulation.

      In a preferred embodiment of the present invention, the polymerization is conducted in two stages. In the first stage, the macromonomer is formed in an aqueous emulsion polymerization process, and in the second stage the  
10   macromonomer is polymerized with the second ethylenically unsaturated monomer in an emulsion. For efficiency, preferably these two stages are conducted in a single vessel. For example, in the first stage, the macromonomer aqueous emulsion may be formed by polymerizing in an aqueous emulsion at least one first ethylenically unsaturated monomer to form water insoluble  
15   macromonomer particles. This first stage polymerization is preferably conducted using a transition metal chelate chain transfer agent as previously described herein. After forming the macromonomer aqueous emulsion, a second emulsion polymerization is preferably performed in the same vessel to polymerize the macromonomer with at least one second ethylenically unsaturated monomer.  
20   This second stage may be conducted for example by directly adding (e.g., all at once or by a gradual feed) the monomer composition and initiator to the macromonomer aqueous emulsion. One main advantage of this embodiment is that the macromonomer does not have to be isolated, and the second polymerization can take place simply by adding the monomer composition and  
25   initiator to the macromonomer aqueous emulsion. In this preferred embodiment, the particle size and particle size distribution of the plural water insoluble macromonomer particles may be precisely controlled, and later addition of more macromonomer aqueous emulsion would typically not be required, except when, for example, a second mode (particle size and/or composition) of graft copolymer  
30   is desired.

In another preferred embodiment of the present invention, the polymerization of the macromonomer and second ethylenically unsaturated monomer is at least partially performed in the presence of an acid containing monomer, acid containing macromonomer, or combinations thereof. The acid  
5 containing monomer or acid containing macromonomer may be added in any manner to the polymerization reaction mixture. Preferably, the acid containing monomer or acid containing macromonomer is present in the monomer composition. The acid containing monomer or acid containing macromonomer may also be added as a separate stream to the polymerization reaction mixture.

10 The amount of acid containing monomer or acid containing macromonomer added to the polymerization reaction mixture is typically from 0 to 10 weight percent, preferably from 0.2 weight percent to 10 weight percent, more preferably from 0.5 weight percent to 5 weight percent, and most preferably from 1 weight percent to 2 weight percent, based on the total weight  
15 of monomer and macromonomer added to the polymerization reaction mixture.

Acid containing monomers which may be used in this embodiment include ethylenically unsaturated monomers bearing acid functional or acid forming groups such as those previously described herein. The "acid containing macromonomer" useful in this embodiment is any low molecular weight polymer  
20 having at least one terminal ethylenically unsaturated group that is capable of being polymerized in a free radical polymerization process, and that is formed from at least one kind of acid containing monomer. Preferably, the amount of acid containing monomer present, as polymerized units, in the acid containing macromonomer is from 50 weight percent to 100 weight percent, more preferably  
25 from 90 weight percent to 100 weight percent, and most preferably from 95 weight percent to 100 weight percent.

The acid containing macromonomer may be prepared according to any technique known to those skilled in the art such as those previously described herein. In a preferred embodiment of the present invention, the acid containing  
30 macromonomer is prepared by a solution polymerization process using a free radical initiator and transition metal chelate complex. Such a process is

disclosed in, for example, US-A-5,721,330. Preferred acid containing monomers used to form the acid containing macromonomer are  $\alpha$ -methyl vinyl monomers such as methacrylic acid.

In another preferred embodiment of the present invention, a  
5 "macromolecular organic compound" having a hydrophobic cavity is present in the polymerization medium used to form the macromonomer and/or aqueous copolymer composition. Typically, the macromolecular organic compound may be used whenever facilitation of transport of monomer, or other ingredient, through the aqueous phase is needed. In this way, even the aqueous phase transport of  
10 monomers having low to moderate water solubility may be facilitated. Preferably, the macromolecular organic compound is used when the monomer to be transported has a water solubility no greater than 150 millimoles/liter. More preferably, the macromolecular organic compound is used when copolymerizing ethylenically unsaturated monomers with very low water solubility such as  
15 lauryl or stearyl acrylates and/or methacrylates. By "very low water solubility" it is meant a water solubility at 25°C to 50°C of no greater than 50 millimoles/liter. For example, the macromolecular organic compound may be added to the monomer composition, the macromonomer aqueous emulsion, or the polymerization reaction mixture used to form the aqueous copolymer  
20 composition. Also, for example, the macromolecular organic compound may be added to an aqueous emulsion of ethylenically unsaturated monomer used to form the macromonomer. Suitable techniques for using a macromolecular organic compound having a hydrophobic cavity are disclosed in, for example, US-A-5,521,266.

25 Preferably, the macromolecular organic compound having a hydrophobic cavity is added to the polymerization reaction mixture to provide a molar ratio of macromolecular organic compound to very low water solubility monomer or macromonomer of from 5:1 to 1:5000 and more preferably from 1:1 to 1:500.

30 Macromolecular organic compounds having a hydrophobic cavity useful in the present invention include for example cyclodextrin or cyclodextrin derivatives; cyclic oligosaccharides having a hydrophobic cavity such as



cycloinulohexose, cycloinuloheptose, or cycloinulooctose; calyxarenes; cavitands; or combinations thereof. Preferably, the macromolecular organic compound is  $\beta$ -cyclodextrin, more preferably methyl- $\beta$ -cyclodextrin.

Monomers having low water solubility include for example primary  
5 alkenes; styrene and alkylsubstituted styrene;  $\alpha$ -methyl styrene; vinyltoluene; vinyl esters of  $C_4$  to  $C_{30}$  carboxylic acids, such as vinyl 2-ethylhexanoate, vinyl neodecanoate; vinyl chloride; vinylidene chloride; N-alkyl substituted (meth)acrylamide such as octyl acrylamide and maleic acid amide; vinyl alkyl or  
10 aryl ethers with ( $C_3$  - $C_{30}$ ) alkyl groups such as stearyl vinyl ether; ( $C_1$  - $C_{30}$ ) alkyl esters of (meth)acrylic acid, such as methyl methacrylate, ethyl (meth)acrylate, butyl (meth)acrylate, 2-ethylhexyl (meth)acrylate, benzyl (meth)acrylate, lauryl (meth)acrylate, oleyl (meth)acrylate, palmityl (meth)acrylate, stearyl (meth)acrylate; unsaturated vinyl esters of (meth)acrylic acid such as those  
15 derived from fatty acids and fatty alcohols; multifunctional monomers such as pentaerythritol triacrylate; monomers derived from cholesterol or combinations thereof.

In another aspect of the present invention an aqueous copolymer composition is provided that is preferably produced by the method of the present invention as previously described herein. The aqueous copolymer composition  
20 contains a plurality of water insoluble particles of comb copolymer. The comb copolymer particles preferably have a weight average particle size of from 60 nm to 1,000 nm, more preferably from 60 nm to 500 nm, and most preferably from 80 nm to 350 nm.

The second ethylenically unsaturated monomer may be any ethylenically  
25 unsaturated monomer that provides desirable properties in the copolymer particles, such as those useful in the monomer composition as previously described herein.

The weight ratio of graft segment to backbone of the comb copolymer of the present invention is preferably 30:70 to 60:40, more preferably 35:65 to  
30 50:50, and most preferably 35:65 to 45:55.

Although the backbone of the comb copolymer may be branched, with such branching including, for example, "star" structures, it is preferred that the backbone is linear. Compositionally, the backbone of the copolymer preferably contains polymerized units of the second ethylenically unsaturated monomer derived from the monomer composition.

Preferably, the Tg of the backbone is from -65°C to 10°C, more preferably from -45°C to 10°C, and most preferably from -40°C to 0°C.

The pendant graft segments of the comb copolymer preferably contain polymerized units of the macromonomer. In a preferred embodiment of the present invention, each graft segment is derived from one macromonomer. Additionally, the pendant graft segments contain less than 5 weight percent and more preferably less than 1 weight percent of the polymerized second ethylenically unsaturated monomer derived from the monomer composition, based on the total weight of the pendant graft segments.

Preferably, the Tg of the graft segment of the comb copolymer is from 60°C to 180°C, more preferably from 70°C to 130°C, and most preferably from 80°C to 120°C.

It is further preferred that the graft segment is miscible with the substrate polymer of the present invention. Although not wishing to be bound by any particular theory, it is thought that this miscibility of the graft segment is desirable because favorable interaction of the graft segment with the substrate polymer enhances adhesion between the capstock layer and the layer of substrate polymer. The solubility parameters of the graft segment and the substrate polymer can be estimated and compared to predict miscibility by methods such as that of Van Krevelen, described herein above.

In a preferred embodiment of the present invention, the water insoluble comb copolymer particles typically contain from 0 weight percent to 10 weight percent, preferably 0.2 weight percent to 10 weight percent, more preferably from 0.5 weight percent to 5 weight percent, and most preferably from 1 weight percent to 2 weight percent of an acid containing macromonomer, based on the

total weight of the graft copolymer. The acid containing macromonomer preferably has a composition as previously described herein.

Although in no way intending to be bound by theory, it is believed that the "acid containing macromonomer" is attached to the surface of the water insoluble graft copolymer particles and provides stability. By "attached," as used herein, it is believed that the acid containing macromonomer is bound in some manner (e.g., covalent, hydrogen bonding, ionic) to a polymer chain in the particle. Preferably, the acid containing macromonomer is covalently bound to a polymer chain in the particle. It has been found that the acid containing macromonomer provides stability to the particles such that the aqueous copolymer composition produced exhibits unexpected improved shear stability; freeze thaw stability; and stability to additives in formulations, as well as reduction of coagulum during the polymerization. Although improved stability can be achieved using acid containing monomer, these benefits are most dramatic when an acid containing macromonomer is used.

The aqueous copolymer composition in addition to the copolymer particles preferably contains less than 10 weight percent, and more preferably less than 1 weight percent of organic solvent. In a most preferred embodiment, the aqueous copolymer composition contains no organic solvent.

An advantage of using the method of the present invention to prepare the aqueous copolymer composition is that the resulting copolymer composition contains low levels of homopolymer, such as for example homopolymer of second ethylenically unsaturated monomer derived from the monomer composition or homopolymer of macromonomer derived from the macromonomer aqueous emulsion. Preferably the aqueous copolymer composition contains less than 30 weight percent and more preferably less than 20 weight percent of homopolymer of macromonomer, based on the total weight of the graft copolymer. Preferably also the aqueous copolymer composition contains less than 30 weight percent and more preferably less than 20 weight percent of homopolymer of second ethylenically unsaturated monomer.

The comb copolymer of the present invention may be isolated as powders, or other solid particles, from dispersions containing it (e.g., aqueous emulsions) by methods well known in the art. These methods include, for example, spray drying, coagulation and oven drying, freeze drying, and devolatilizing extrusion.

5       The substrate composition and, hence, the substrate layer of the present invention may include any thermoplastic polymer known to the art. Preferably, the thermoplastic polymer is a polymer selected from the group consisting of poly(vinyl halide), chlorinated poly(vinyl chloride), ABS terpolymer, polyaromatics including high impact polystyrene (HIPS), polyamides, polyesters,  
10 polyolefins including polypropylene, and combinations thereof. More preferably, the thermoplastic polymer is a polymer selected from the group consisting of poly(vinyl chloride), ABS terpolymer, and combinations thereof. Most preferably, the thermoplastic polymer is poly(vinyl chloride). The acronyms in parentheses above are the ASTM D4000 acronyms.

15       The term "poly(vinyl halide)" is used generically herein to define not only poly(vinyl chloride), but also analogous polymers, such as poly(vinyl bromide), and chlorinated polyvinyl chloride; poly(vinylidene chloride) and its derivatives, including poly(vinylidene chloride-vinyl acetate); and vinyl chloride copolymers or terpolymers having vinyl chloride as the major component (greater than 50%  
20 by weight). These copolymers and terpolymers include, as polymerized units, comonomers of vinyl alkanoates such as vinyl acetate; vinylidene halides such as vinylidene chloride; alkyl esters of carboxylic acids such as acrylic acid, ethyl acrylate, and 2-ethylhexyl acrylate; unsaturated hydrocarbons such as ethylene, propylene, and isobutylene; and, allyl compounds, such as allyl acetate.

25       The term "ABS terpolymer" is used generically herein not only to define a terpolymer of acrylonitrile, butadiene, and styrene, but also analogous polymers in which the ABS comonomers have been replaced in whole or in part by analogous comonomers, as polymerized units. For example, acrylonitrile is replaced by, or supplemented with methacrylonitrile, ethacrylonitrile, or  
30 halogenated acrylonitriles; styrene is replaced by, or supplemented with alpha-

methyl styrene, chlorostyrene, or vinyl toluene; butadiene is replaced by, or supplemented with isoprene.

The "solid capstock layer" of the present invention can be prepared by forming and melt processing a "capstock composition". The capstock composition  
5 includes a comb copolymer. The comb copolymer may be melt processed as is, or in combination with additives as are described herein below. If additives are included, they may be combined with the comb copolymer by blending methods well known to those skilled in the art. For example, a Henschel Blender (available from Henschel Mixers Americas, Houston, Texas), may be used to  
10 blend the comb copolymer with additives, including, for example, other comb copolymers. Hand blending (e.g., by shaking the components of the capstock composition in a bag) may also be employed, as may be pre-extrusion to form pellets.

The capstock composition is then, typically, fed to the feed section of a first  
15 extruder. The screw or screws (e.g., of single or twin-screw extruders, respectively) of the first extruder then convey the capstock composition to the metering section where mixing and heating occur to form a "capstock melt". The metering section of the extruder may have multiple zones and may also have multiple screw sections, each having a different design. The capstock melt is  
20 maintained at a temperature above the temperature at which it becomes fluid and below the temperature at which significant decomposition would occur before the capstock melt could exit the first extruder. The optimum melt temperature will, of course, vary according to the capstock composition being mixed and heated. Typically, this melt temperature will be between 100°C and  
25 250°C.

The capstock melt is then conveyed to a die where it is formed into a "capstock melt layer" which is, in turn, extruded through the exit opening of the die. The capstock melt layer is cooled by air or other cooling fluid as it exits the die. Often the die itself is cooled by a cooling fluid (e.g., water, or oil) so that  
30 cooling of the capstock melt begins within the die block. The cooling of the capstock melt layer converts it to a "solid capstock layer" which is the capstock

layer of the multi-layer polymeric composite. The thickness of the capstock layer may be several millimeters, but is, preferably 10 to 1,000 microns, more preferably 25 to 500 microns, and most preferably, 25 to 250 microns.

5 The "solid substrate layer" of the present invention is formed in a manner similar to that used to form the capstock layer, beginning with the formation of a "substrate composition" which includes a thermoplastic polymer, and may include additives such as are described herein below. The substrate composition is then, typically, fed to the feed section of a second extruder. The screw or screws of the second extruder then convey the substrate composition to the  
10 metering section where mixing and heating occur to form a "substrate melt". The metering section of the extruder may have multiple zones and may also have multiple screw sections, each having a different design. The substrate melt is maintained at a temperature above the temperature at which it becomes fluid and below the temperature at which significant decomposition would occur  
15 before the substrate melt could exit the second extruder. The optimum melt temperature will, of course, vary according to the substrate composition being mixed and heated. Typically, this melt temperature of the substrate melt will be between 100°C and 350°C. For example, the processing temperature for melts of poly(vinyl chloride) is characteristically in the range of 185°C to 205°C.

20 The substrate melt is then conveyed to a die where it is formed into a "substrate melt layer" which is, in turn, extruded through the exit opening of the die of the second extruder. The substrate melt layer is cooled by air or other cooling fluid as it exits the die. Often the die itself is cooled by a cooling fluid (e.g., water, or oil) so that cooling of the substrate melt begins within the die  
25 block. The cooling of the substrate melt layer converts it to a "solid substrate layer" which is the substrate layer of the multi-layer polymeric composite. The thickness of the substrate layer is, preferably 10 to 1,000 microns, more preferably 25 to 500 microns, and most preferably, 25 to 250 microns.

Typically, the first and second extruder are arranged so that their  
30 extruder barrels converge such that their die areas are in intimate contact, thereby allowing the capstock melt layer to contact the substrate melt layer as

those melt layers exit their respective dies. In this way, the capstock melt layer becomes disposed upon the substrate melt layer, adhering thereto, thereby forming a "multi-layered melt composite". As the capstock melt layer and substrate melt layer cool, they form the solid capstock layer and the solid substrate layer of the multi-layered polymeric composite of the present invention. Co-extruders may include more than two extruders, and multi-layered polymeric composites having more than two layers may be prepared by the method of the present invention. The multi-layered composite so formed may include more than one substrate layer, or even more than one capstock layer.

In addition to co-extrusion, multi-layered polymeric composites may be prepared using, for example, presses, molds, injection molds, and blow molds. Any type of thermoplastic article common to the art may be made by the method of the present invention. A non-exhaustive list of these articles includes, for example, construction materials, such as siding, pipe, wallboard, wall-covering, and window frame; films and laminates; appliance housings such as housings for computers, refrigerators, and air conditioners; both interior and exterior automotive parts; packaging materials; and toys.

Certain lubricants, stabilizers, and the like are often incorporated into the capstock composition, and hence the capstock melt layer and the solid capstock layer. The stabilizers serve to prevent the breakdown of the thermoplastic polymer and are of several different types. Two varieties stabilize against thermal and ultraviolet light stimulated oxidative degradation, mechanical degradation, and discoloration.

Other additives to the capstock composition, and capstock melt layer and solid capstock layer, prepared in accordance with the present invention may include, for example, colorants, including organic dyes, such as anthraquinone red, organic pigments such as phthalocyanine blue, and inorganic pigments such as titanium dioxide, zinc oxide, and cadmium sulfide. Polymeric or inorganic fillers and particulate extenders can be added to reduce cost and reduce gloss. Examples are carbon black, amorphous silica, asbestos, talc, calcium carbonate, magnesium carbonate, clays, and glass or carbon fibers. Large particle size

polymeric matting or flattening agents may be added. The capstock composition may include more than one type of comb copolymer. The capstock composition may also include thermoplastic polymers compatible with the comb copolymer. Compatible thermoplastic polymer include, for example acrylic, poly(vinyl chloride), and vinylidene fluoride copolymer. It may further include other impact modifiers, such as typical crosslinked core/shell poly(butadiene/styrene)/poly(methacrylate) modifiers and crosslinked poly(butyl acrylate)/poly(methacrylate).

All of the additives just enumerated, may, optionally, be included in the substrate composition, and hence the substrate melt layer and solid substrate layer, of the present invention.

While only a few of such materials have been specifically recited, it is not intended to exclude others; the recitation is exemplary only, and each category of additives is common and well-known in the art. The inclusions can be made at any stage of preparation in accordance with accepted techniques well-known to those ordinarily skilled in the art, in proportions which are commonly employed. Such additional materials are not of particular significance in the present invention.

#### Experimental

##### Molecular Weight Determination using Gel Permeation Chromatography (GPC)

Gel Permeation Chromatography, otherwise known as size exclusion chromatography, actually separates the members of a distribution of polymer chains according to their hydrodynamic size in solution rather than their molar mass. The system is then calibrated with standards of known molecular weight and composition to correlate elution time with molecular weight. The techniques of GPC are discussed in detail in *Modern Size Exclusion Chromatography*, W. W. Yau, J. J. Kirkland, D. D. Bly; Wiley-Interscience, 1979, and in *A Guide to Materials Characterization and Chemical Analysis*, J. P. Sibilio; VCH, 1988, p.81-84.

For example, the molecular weight information for a low molecular weight sample (e.g., 10,000) may be determined as follows: The sample (an aqueous



emulsion containing low molecular weight particles) is dissolved in THF at a concentration of approximately 0.1% weight sample per volume THF, and shaken for 6 hours, followed by filtration through a 0.45 $\mu$ m PTFE (polytetrafluoroethylene) membrane filter. The analysis is performed by  
5 injecting 100 $\mu$ l of the above solution onto 3 columns, connected in sequence and held at 40°C. The three columns are: one each of PL Gel 5 100, PL Gel 5 1,000, and PL Gel 5 10,000, all available from Polymer Labs, Amherst, Massachusetts. The mobile phase used is THF flowing at 1 ml/min. Detection is via differential refractive index. The system was calibrated with narrow polystyrene standards.  
10 PMMA-equivalent molecular weights for the sample are calculated via Mark-Houwink correction using  $K=14.1\times 10^{-3}\text{ml/g}$  and  $a=0.70$  for the polystyrene standards and  $K=10.4\times 10^{-3}\text{ml/g}$  and  $a=0.697$  for the sample.

### Synthesis Examples

15 Some embodiments of the invention will now be described in detail in the following Examples. The following abbreviations shown in Table 1 are used in the examples:

#### Table 1: Abbreviations

Abbreviation	
A-16-22	Polystep A-16-22, anionic surfactant, supplied as 22% solids by Stepan Company, located in Northfield, Illinois.
BA	Butyl acrylate
EA	Ethyl acrylate
MMA	Methyl methacrylate
BMA	Butyl methacrylate
MAA	Methacrylic acid
CoBF	Co(II)-(2,3-dioxyiminobutane-BF <sub>2</sub> ) <sub>2</sub>
CVA	4,4'-azobis(4-cyanovaleric acid)
Fe	0.15% Ferrous sulfate in water
DBS	Dodecyl benzene sulfonate
GC	Gas chromatograph
SEC	Size exclusion chromatography
HPLC	High performance liquid chromatography
Init.	Initiator
IR	Infrared spectroscopy
LCCC	Liquid chromatography under critical conditions
NaPS	Sodium persulfate
Na <sub>2</sub> CO <sub>3</sub>	Sodium bicarbonate
Mn	Number average molecular weight
MM	Macromonomer
PMAA-MM	Poly-methacrylic acid macromonomer
MM	Macromonomer
PMMA-MM	Poly-methyl methacrylate macromonomer
Poly-(BA-g-BMA)	Graft copolymer of BA with BMA side chains
Poly-(BA-g-MMA)	Graft copolymer of BA with MMA side chains
Wako VA-044	2,2'-azobis[2-(2-imidazolin-2-yl)propane] dihydrochloride

In the Examples, monomer conversion was determined by GC analysis of unreacted monomer using standard methods. Weight percent solids for the macromonomer and copolymer compositions were determined by gravimetric analysis. Particle size of the macromonomer and copolymer compositions were obtained using a Matec CHDF 2000 particle size analyzer equipped with a HPLC type Ultra-violet detector.

Macromonomer was measured for number average molecular weight by SEC using a polystyrene standard from Polymer Laboratories (PS-1) having a peak average molecular weight ranging from 580 to 7,500,000 with narrow molecular weight distribution. Conversions from polystyrene to PMMA were made using Mark-Houwink constants. Copolymer compositions were evaluated for number average molecular weight and weight average molecular weight using SEC as described above.

### Examples 1.1 to 1.4 -- Preparation of Macromonomers by Emulsion Polymerization

Macromonomer (MM) was prepared by emulsion polymerization processes in Examples 1.1 to 1.4. The polymerization was conducted in a 5-liter, four neck round bottom reaction flask equipped with a mechanical stirrer, temperature control device, condenser, monomer feed line and a nitrogen inlet except for example 1.3 which was prepared in a 5 gallon reactor with similar attachments. The specific amounts of water, surfactant, monomers, chain transfer agent (CTA), and initiator used in Examples 1.1 to 1.4 are shown in Table 2. These ingredients were added according to the following procedure. In a different flask from the reaction flask, a monomer solution was prepared by dissolving the chain transfer agent in the monomer mixture consisting of all the monomers listed in Table 2 under a nitrogen purge. Deionized water and surfactant were introduced into the reaction flask at room temperature to form a water surfactant solution. The water surfactant solution was mixed and heated to 80 °C with stirring under a nitrogen purge. Upon reaching a temperature of 80 °C, and upon complete dissolution of the surfactant, the initiator (CVA) was added to the water surfactant solution with stirring for 2 minute to permit the initiator to dissolve. After dissolution of the initiator, MMA (350 g for example 1.3 and 63 g for examples 1.1 and 1.2, respectively) was introduced into the reaction flask and allowed to react for 10 minutes. An acrylic latex polymer was used as a seed for example 1.4 (241 g of a acrylic latex with particle size of 150 nm and solids at 30%). At the end of 10 minutes, 20 percent by weight of the monomer solution was added to the reaction flask with stirring. Following this initial charge, the remaining monomer solution was fed over a period of 2 hours, with stirring, to form a reaction mixture. At the end of the feed period, the reaction mixture was maintained at 80°C for an additional 2 hours. The reaction mixture was then cooled to room temperature and passed through a filter cloth to remove any coagulum.

Generally, the resulting macromonomer emulsion contained less than 5 weight percent coagulum based on the total weight of macromonomer, and the conversion of monomer was over 99 weight percent, based on the total weight of monomer added. The Mn, weight percent solids and particle size for each macromonomer are reported in Table 2.

Table 2: Preparation of Macromonomers (MM)

Exmp l.	H <sub>2</sub> O (g)	Surf (g) ( <sup>3</sup> )	MM A (g)	MA A (g)	EA (g)	CTA <sup>(1)</sup> (g)	Init. <sup>(2)</sup> (g)	Part Size (nm )	Mn	Wt % Solid s
1.1	2380	55	838	59.8	299. 4	0.16	12.6	104	1264 3	33.3
1.2	2350	55	1137	59.8	---	0.14	12.6	95	1138 2	33.6
1.3	1323 2	306	6655	---	---	0.42	70	83	3937	34.1
1.4	2380	45	1160	---	---	0.14	13.5	110	1011 2	32.6

(1) Chain transfer agent (CoBF).

(2) CVA, supplied by Aldrich as a 75 weight percent aqueous solution of initiator.

(3) A-16-22

#### 5 Example 2. Preparation of PMAA-MM By Solution Polymerization.

MAA macromonomer (PMAA-MM) was prepared by aqueous solution polymerization in a 2-liter baffled flange flask equipped with a mechanical stirrer, condenser, temperature control device, initiator feed lines and a nitrogen inlet. The apparatus was purged with nitrogen for 30 minutes after 0.018g of CoBF was added. Deionized water, 1080 g, was charged to the flask and heated to 55°C under a nitrogen purge. A monomer mixture containing 510 ml of MAA and 0.01 g of CoBF was prepared separately under nitrogen. When the deionized water reached a temperature of 55°C, 1.94 g of initiator (Wako VA-044) was added to the reaction flask. Following the addition of the initiator, the monomer mixture was added over a period of 60 minutes to the reaction flask with stirring. The temperature was then held at 55°C for 2 hours following completion of the monomer mixture feed. Upon cooling the reaction flask to room temperature, the MAA-MM (Example 2.1) was isolated as dried polymer by rotary evaporation. The number average molecular weight (Mn) of the MAA-MM was determined by proton nuclear magnetic resonance to be 4030 based on the integration of the vinyl end group with respect to the methyl and methylene groups of the polymer chain.

Example 3. Preparation of Acrylic graft copolymers by Semi-continuous Process.

In Examples 3.1 to 3.8, graft copolymers were prepared by a semi-continuous emulsion polymerization process in a 5-liter round bottom flask with four neck equipped with a mechanical stirrer, temperature control device, initiator feed lines and a nitrogen inlet. The specific amounts of Macromonomer (MM, as emulsion), water, surfactant, monomers, acid containing monomers, and initiator used in Examples 3.1 to 3.8 are shown in Table 3. These ingredients were added according to the following procedure. A monomer emulsion of deionized water (H<sub>2</sub>O #2 in Table 3), surfactant, and monomers (as listed in Table 3) was prepared in a separate flask. Deionized water (H<sub>2</sub>O #1 in Table 3), MM from the example indicated in Table 1 and 20% of the monomer emulsion were introduced into the reaction flask at room temperature to form a reaction mixture. The reaction mixture was heated to 85°C while stirring under a nitrogen purge. Upon reaching 85°C, the initiator and buffer solutions were introduced into the reaction flask. The remaining monomer emulsion was added over a period of 30 minutes with the temperature maintained at 90°C. Upon completion of the feeds, the reaction mixture was maintained at the reaction temperature for a period of 1 hours. The resulting copolymer composition was analyzed for conversion and other properties as described in Table 4. The conversion of BA, determined by standard GC methods, was greater than 99 weight percent based on the total weight of BA charged.

**Table 3: Preparation of Acrylic Graft Copolymers by Semi-Continuous Process**

Exm pl.	MM <sup>(1)</sup>		H <sub>2</sub> O #1 (g)	H <sub>2</sub> O #2 (g)	Surf <sup>(2)</sup> (g)	BA (g)	MM A (g)	Acid (g)	Init. <sup>(4)</sup> (g)	Buffer <sup>(5)</sup> (g)	Add (g)
	Exmp l.	Amt (g)									
3.1	1.1	184 4	100	175	29.7	892	223	26.3 (6)	1.2	1.22	
3.2	1.2	914	575	101	14.9	541	29	---	0.6	---	0.44 (7)
3.3	1.3	231 6	450	270	22.5	790	---	---	1.1	---	
3.4	1.4	955	575	101	14.9	452	29	13.3 (6)	0.6	0.61	
3.5	1.3	488	170	158	7.9	309	---	---	0.3	---	
3.6	1.4	122 7	600	150	16.7	480	120	---	0.7	---	
3.7	1.4	122 7	600	150	16.7	420	180	---	0.7	---	

3.8	1.4	122 7	600	150	16.7	360	240	---	0.7	---	
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(1) Macromonomer emulsion prepared by method of Example 1.

(2) Ethoxylated C<sub>6</sub> to C<sub>18</sub> alkyl ether sulfate having from 1 to 40 ethylene oxide groups per molecule (30% active in water). Except for example 3.1.

(4) NaPS dissolved in 10g of water.

5 (5) Sodium carbonate dissolved in 15g of water.

(6) PMAA-MM (prepared by method of Example 2.1)

(7) Dodecylmercaptan

### Characterization of Example 3 Copolymer Compositions.

10 Graft copolymer compositions prepared in the previous examples were characterized by various analytical techniques to determine wt% solids, particle size, weight average molecular weight, number average molecular weight, and percent incorporation of macromonomer.

15 Determination of the amount of unreacted macromonomer was carried out by HPLC analysis using the following procedure. The copolymer compositions were dissolved in THF and analyzed by gradient elution on an LC-18 column supplied by Supelco, located in Bellefonte, PA such that a well-isolated peak was observed for the unreacted macromonomer. Quantification was carried out by calibrating the detector response using known standards of the same macromonomer employed in the synthesis. The results of the characterization  
20 are reported in Table 4 below.

**Table 4: Characterization of Copolymer Compositions**

Example	% Solids	Particle Size (nm)	Mw (x 10 <sup>-3</sup> )	Mn (x 10 <sup>-3</sup> )	PMMA-MM Incorp. <sup>(1)</sup> (wt%)
3.1	45.4	128	482	127	
3.2	38.8	113	997	182	92
3.3	40.3	104	771	184	92
3.4	34.4	166	360	162	
3.5	40.1	209	200	24	83
3.6	40	100	365	153	88
3.7	40	100			
3.8	40	100			

(1) Based on the total weight of macromonomer added to reaction vessel.

### Dropping Dart Impact Resistance Test Method (see Table 5).

25 The impact resistance method used to test the specimens of capstock material was the dropping dart impact resistance test - ASTM method D-446 with impact head configuration H.25. Testing was done on 1 mm substrates

prepared in the following manner: Dry powders were mixed to form mixtures without melting using a high intensity mixer. Dry powder mixtures were melt blended using a Collin Mill (W.H. Collin GmbH Maschinenfabrik, Aichach, Germany) at 190°C for 6 minutes. Test plaques were prepared using a Reliable Press (Reliable Press Co., Cleveland, Ohio) operating at a temperature of 190°C. The pressing operation applied 69 MPa for 3 minutes, followed by 496 MPa for 2 minutes and a 3-minute cooling period (room temperature) at 496 MPa.

#### Tensile Test Method (see Table 5).

Test films were prepared as for impact testing herein above. Tensile testing was done on an Instron tensile tester at a crosshead speed of 2.54 cm/min. The gauge length was 2.54 cm and samples were rectangular in shape with dimensions 1 mm x 12.7 mm x 76.2 mm. Tensile strength at break (force at break / initial cross section area), and percent elongation at break were measured (Extension at break · gauge length)/ gauge length). Young's modulus is the slope of the stress - strain curve during the initial, linear portion of the curve.

#### Stress Whitening Resistance Test Method (see Table 5).

Subsequent to the impact event, test specimens from the Dropping Dart Impact Resistance Test were examined for stress whitening around the area where the dart impacts the specimen. The rating was pass/fail. A material either shows stress whitening or the material is unchanged in appearance (i.e., no whitening) in the area of impact.

**Table 5. Performance properties of capstock layers.**

Examp le No.	Composition of Capstock Layer	Dart Impact Energy 1.016 mm film <sup>(4)</sup> (joules)	Stress whitening at impact area	Tensile Strength (MPa)	Elong at Brea k %	Young's Modulus (MPa)
C-1 <sup>(3)</sup>	<sup>(1)</sup> Acrylic Capstock 9869 EXP (Rohm and Haas, PA)	3.3	Fail	13.8	120	399.9
C-2 <sup>(3)</sup>	<sup>(2)</sup> Tufcoat 4600 (Ineos Acrylics, TN)	2.9	Fail	22.8	140	592.9

4	Example 3.1 63.5% (80 BA/20 MMA)// 35% (70 MMA/25 EA/5MAA) MM/ 1.5 MAA MM <sup>(5)</sup>	16.7	Pass	6	400	48.3
5	Example 3.2 65% (95 BA/5 MAA)// 35% (95 MMA/5MAA) MM	6.2	Pass	7.4	220	117.2
6	Example 3.5 65 BA / 35 MMA MM	4.5	Pass	7.2	213	61.4
7	Example 3.6 60% (80 BA/20 MMA)/ 40% MMA MM	6.7	Pass	10.5	320	100.7
8	Example 3.4 59.7% (94 BA/6 MMA)// 38.7 MMA MM / 1.6 MAA MM	6.3	Pass	8.3	180	131
9	Example 3.3 50 BA// 50 MMA MM	3.3	Pass	13.6	140	406

- (1) Blend approach using a blend of core-shell impact modifier and thermoplastic resin (EP 1,061,100)
- 5 (2) Blend approach using a blend of impact modifier and thermoplastic resin (WO 00/08,098)
- (3) The "C-" designation indicates that the example is a comparative example.
- 10 (4) The dropping dart test specimens (using ASTM method D-446 ) have a thickness of 40 mils (= 1.016 millimeters).
- (5) Herein, "MM" used alone refers to "macromonomer".